

# ROYAL – 8018 W (E 8018 W2)

AWS : A/SFA 5.5, E 8018 W2 EN ISO 2560 A E 46 5 Z B 32 H5

## Applications

Ideal for welding high tensile steel. Specially recommended for weathering steel like CORTEN A and B and their equivalents used in Chemical, Petrochemical, Railway, Industries to resist atmospheric corrosion.

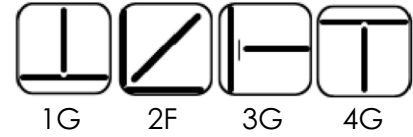
## Characteristics on Usage

It is basic coated hydrogen controlled low alloy high tensile type electrode gives weld deposit of approx 0.6% Cr, 0.70% Ni and 0.50% Cu. which is highly resistance of atmospheric Corrosion. It gives a smooth arc medium penetration with easily removable slag. Easy to operate in all positions. Redry electrode at 250°C 2 hour for better results.

## Notes On Usage

- ☞ Dry the electrode a 250-350°C for 60 Min- before use .
- ☞ Keep the arc as short as possible.

## Welding Positions



LOW ALLOY HIGH TENSILE ELECTRODES

## Chemical Composition Of Weld Metal

C%	Mn%	Si%	S%	P%	Cr %	Ni %	Cu%
0.12 Max	0.50-1.30	0.35-0.80	0.030 Max	0.030 Max	0.45-0.70	0.40-0.80	0.30-0.75

## Mechanical Properties Of Weld Metal

U.T.S. (N/mm <sup>2</sup> )	Y.S. (N/mm <sup>2</sup> )	ELONGATION ( L = 4d ) %	Weld deposit Hardness as welded condition	Diffusible Hydrogen contain in 100-grm weld metal deposit	CVN IMPACT AT - 20°C ( J )
550 Min	460 Min	19 % Min	190 – 200 HV	5 ml Max	47 Joules Min

## Packing and Welding Current

SIZE ( mm )	KG PER PACKET	KG PER CARTON	Current (Amps)	In Amps
2.50 x 350	5	20	AC/DC (+)	60-90
3.15 x 450	5	20		100-140
4.00 x 450	5	20		140-180
5.00 x 450	5	20		180-250
6.30 x 450				250-300